Work Order ID 66297

February 9, 2011 11:41:14 AM

Item ID: D2597 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: 204 Web

Start Date: 2/09/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 2/23/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/02/09 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2597	Rev D								
100	Skidtubes	0.00							
Skidtubes	**Memo**	0.00				2			11/02/09
Skidtubes	Cut D2500-3 to length: 84.25"□Use Jig DT8094 to drill pilot holes.□Open ~~0.625 diameter using a uni-bit.~~ holes to sizes as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				2			11/02/09
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00				2			11/02/09
Hand Finishing									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 66297

February 9, 2011 11:41:14 AM

Item ID: D2597 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 204 Web

Start Date: 2/09/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 2/23/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00	DP		11-2-9	____	____	____	____
QC	**Memo**	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: 46	0.00				2	____	B	11/02/09
Packaging	**Memo**	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00				____	____	____	11/02/11
QC	**Memo**	0.00							
Quality Control									

MF 11-02-11

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

February 9, 2011 11:41:13 AM

Work Order ID: 66297

Parent Item: D2597

Parent Item Name: 204 Web

Start Date: 2/09/11 **Required Date:** 2/23/11

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP: D□98.10.15□Eliminated DEO, Changed Dwg Revision□KS□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			110	Each	48.0000	1	2			
Ext'n - 'I' Beam Web 4"													

Location	Loc Qty	Loc Code
LG	48	
51957	48	

2

11/02/09

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

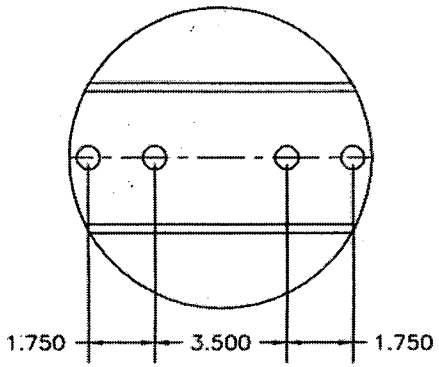
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

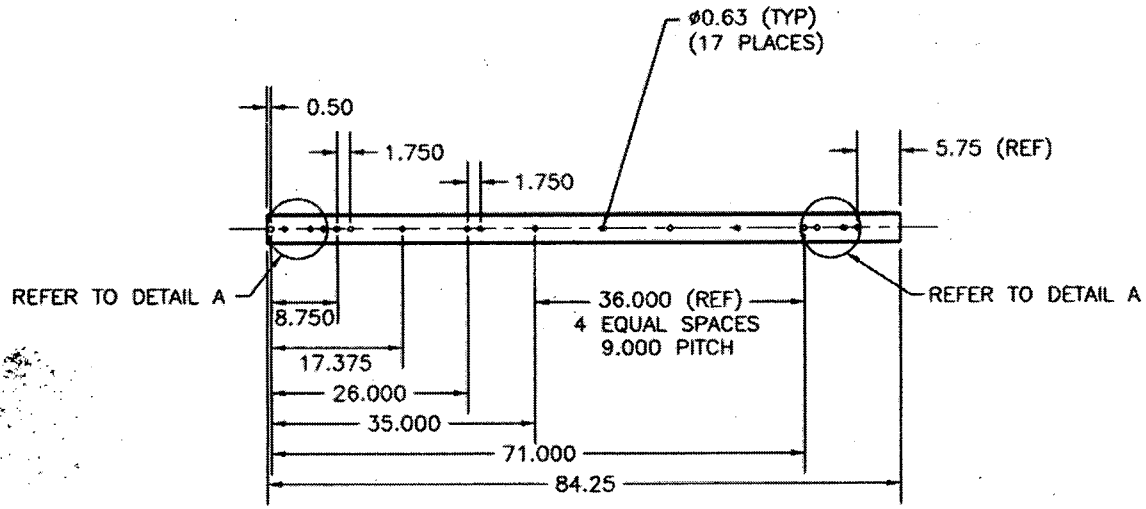
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



RELEASED
98.9.11 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66297



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	96.09.16	NEW ISSUE
B	96.10.29	5.75 WAS 0.50
C	97.07.23	ø0.63 WAS ø0.56
D	98.09.14	INCORPORATED DEO 9097

DART

DESIGN
CHECKED
DRAWN BY
APPROVED
DATE 98.09.14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2597
REV. D
TITLE 204 WEB
SHEET 1 OF 1
SCALE 1:24

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